

वस्त्रादि — हथकरघा सूती हॉलैंड कपड़ा,  
अनभिमार्जित — विशिष्टि  
(दूसरा पुनरीक्षण)

**Textiles — Handloom Cotton Holland  
Cloth, Unscoured — Specification**  
( *Second Revision* )

ICS 59.080.30

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## FOREWORD

This Indian Standard (Second Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by the Handloom and Khadi Sectional Committee had been approved by the Textiles Division Council.

This standard was first published in 1957 and subsequently revised in 1987. The standard has again been revised to incorporate the following changes:

- a) Test method for identification of material has been incorporated;
- b) Method of test for count of yarn along with its tolerance has been specified;
- c) Marking clause has been modified;
- d) References to standards have been updated; and
- e) Sampling plan has been modified.

The composition of the Committee responsible for the formulation of this standard is given in [Annex B](#).

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 2022 'Rules for rounding off numerical values (*second revision*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

*Indian Standard***TEXTILES — HANDLOOM COTTON HOLLAND CLOTH,  
UNSCOURED — SPECIFICATION***( Second Revision )***1 SCOPE**

**1.1** This standard prescribes constructional particulars and other requirements of handloom cotton holland cloth, unscoured.

**1.2** This standard does not specify the general appearance, lustre, feel, finish, etc of the cloth.

**2 REFERENCES**

The standards listed in [Annex A](#) contain provisions, which through reference in this text, constitute provisions of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision and parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent edition of these standards.

**3 MANUFACTURE****3.1 Yarn**

The cotton yarn used in the manufacture of cloth shall conform to IS 171.

The warp used in the manufacture of cloth shall be unbleached, and the weft, grandrelle yarn (*see Note*) and shall be such that the cloth produced complies with the requirements of this standard.

NOTE — Grandrelle yarn has been defined as a two-ply yarn composed of single yarns which differ from each other in colour or lustre (*see IS 232*).

**3.2 Cloth**

The cloth shall be free from substances liable to cause subsequent tendering.

**4 REQUIREMENTS**

**4.1** The constructional particulars of cloth shall conform to those given in [Table 1](#).

**4.2** The cloth shall also conform to the requirements given in [Table 2](#).

**4.3** If in order to illustrate or specify the indeterminable characteristics such as general

appearance, lustre, feel and shade of the cloth, a sample has been agreed upon and sealed, the supply shall be in conformity with the sample in such respects.

The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

**5 INSPECTION**

The cloth when visually inspected, should be reasonably free from following defects:

- a) Weft crack or more than two missing picks across the width;
- b) Prominently noticeable weft bar due to the difference in raw material, count, twist, lustre, shade, etc;
- c) More than two adjacent ends running parallel, broken or missing and extending beyond 15 cm;
- d) Prominent selvedge defects;
- e) Noticeable warp or weft float;
- f) Noticeable oil or other stains;
- g) Noticeable hole, cut or tear up to 3 mm in size; and
- h) Smash rupturing the texture of the fabric.

A reference may be made to IS 14466 for details of the defects.

**6 SAMPLING****6.1 Lot**

The quantity of handloom cotton holland cloth of the same variety, width and colour delivered to a buyer at a time shall constitute a lot.

**6.2** To ascertain the conformity of the lot to the requirements of this standard, sample shall be drawn and inspected from each lot separately.

**6.3** The number of pieces to be selected at random for inspection shall be in accordance with [Table 3](#).

**6.4 Number of Tests and Criteria for Conformity**

<i>Sl No.</i>	<i>Characteristic</i>	<i>Number of Tests</i>	<i>Criteria for Conformity</i>
(1)	(2)	(3)	(4)
i)	Visual inspection, ends, picks, count, length and width	According to col (3) of <a href="#">Table 3</a>	Number of non-conforming pieces shall not exceed the corresponding number given in col (4) of <a href="#">Table 3</a>
ii)	Dimensional change, weight, colour fastness, fibre identification and scouring loss	According to col (5) of <a href="#">Table 3</a>	All the pieces shall meet the requirement

**7 MARKING**

**7.1** The cloth shall be suitably marked or labelled with the following information:

- a) Name of the material;

- b) Manufacturer's name, initials or trade-mark;
- c) Month and year of manufacture;
- d) Length and width of the piece;
- e) Indication of the source of manufacture; and
- f) Other declarations required as per law in force.

**7.2 BIS Certification Marking**

The product(s) conforming to the requirements of this standard may be certified as per the conformity assessment schemes under the provisions of the *Bureau of Indian Standards Act, 2016* and the Rules and Regulations framed thereunder, and the product may be marked with the Standard Mark.

**8 PACKING**

Unless otherwise agreed upon by the buyer and the seller, the cloth shall preferably be packed in bales or cases in conformity with the procedure laid down either in IS 1347 or IS 293.

**Table 1 Constructional Particulars of Handloom Cotton Holland Cloth, Unscoured**

([Clause 4.1](#))

<i>Sl No.</i>	<i>Characteristic</i>	<i>Requirements</i>	<i>Method of Test, Ref to</i>
(1)	(2)	(3)	(4)
i)	Count of yarn (approx) (for guidance only) Tex (cotton count):		IS 3442
	a) Warp	37 (or 16s) $\pm$ 5 percent	
	b) Weft	59 (or 10s) $\pm$ 5 percent	
ii)	Number of threads, per dm:		IS 1963
	a) Ends	200 $\pm$ 5 percent	
	b) Picks	170 $\pm$ 5 percent	
iii)	Weight of fabric, g/m <sup>2</sup>	200 $\pm$ 5 percent	IS 1964
iv)	Dimensions:		IS 1954
	a) Length, m	As declared or agreed ( <i>see Note</i> )	
	b) Width, cm	71, 76, 91 or as agreed (- 2 percent tolerance)	
v)	Weave	plain	visual

NOTE — The length shall not be less than that declared.

**Table 2 Requirements of Handloom Cotton Holland Cloth, Unscoured***(Clause 4.2)*

SI No.	Characteristic	Requirements	Method of Test, Ref to
(1)	(2)	(3)	(4)
i)	Colour fastness rating to:		
	a) Light	4 or better	IS/ISO 105-B01 or IS/ISO 105-B02
	b) Washing test 4:		IS/ISO 105-C10
	1) Change in colour	3 or better	
	2) Staining on cotton	3 or better	
ii)	Scouring loss, percent, <i>Maximum</i>	10	IS 1383
iii)	Dimensional change, percent, <i>Maximum</i>	5	IS 9
iv)	Fibre identification	100 percent cotton	IS 667

**Table 3 Sample Size and Permissible Number of Non-Conforming Pieces***(Clauses 6.3 and 6.4)*

SI No.	Lot Size	Sample Size	Permissible No. of Non-Conforming pieces	Sub Sample Size
(1)	(2)	(3)	(4)	(5)
i)	Up to 90	5	0	3
ii)	91 to 150	8	0	3
iii)	151 to 500	13	1	5
iv)	501 to 1 200	20	1	5
v)	1 201 to 10 000	32	2	8
vi)	10 001 to 35 000	50	3	8
vii)	35 001 to 500 000	80	5	13
viii)	500 001 and above	125	7	13

## ANNEX A

*(Clause 2)*

## LIST OF REFERRED STANDARDS

<i>IS No.</i>	<i>Title</i>	<i>IS No.</i>	<i>Title</i>
IS 9 : 2019/ ISO 675 : 2014	Textiles — Woven fabrics — Determination of dimensional change on commercial laundering near the boiling point ( <i>third revision</i> )	IS 1347 : 1972	Specification for inland packaging of cotton cloth and yarn ( <i>first revision</i> )
IS/ISO 105-B01 : 2014	Textiles — Tests for colour fastness: Part B01 Colour fastness to light: Daylight	IS 1383 : 2023	Methods for determination of scouring loss in grey and finished cotton textile materials ( <i>second revision</i> )
IS/ISO 105-B02 : 2014	Textiles — Tests for colour fastness: Part B02 Colour fastness to artificial light: Xenon arc fading lamp test	IS 1954 : 2024/ ISO 22198 : 2006	Textiles — Fabrics — Determination of width and length ( <i>third revision</i> )
IS/ISO 105-C10 : 2006	Textiles — Tests for colour fastness: Part C10 Colour fastness to washing with soap or soap and soda	IS 1963 : 1981	Methods for determination of threads per unit length in woven fabrics ( <i>second revision</i> )
IS 171 : 1993	Textiles — Ring spun grey cotton yarn for weaving — Specification ( <i>fourth revision</i> )	IS 1964 : 2001	Textiles — Methods for determination of mass per unit length and mass per unit area of fabrics ( <i>second revision</i> )
IS 232 : 2020	Glossary of textile terms — Natural fibres ( <i>third revision</i> )	IS 3442 : 2023	Textiles — Method for determination of crimp and linear density of yarn removed from fabric ( <i>second revision</i> )
IS 293 : 1980	Code for seaworthy packaging of cotton yarn and cloth ( <i>third revision</i> )	IS 14466 : 1997/ ISO 8498 : 1990	Fabrics — Description of defects — Vocabulary
IS 667 : 1981	Methods for identification of textile fibres ( <i>first revision</i> )		

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## ANNEX B

*(Foreword)*

## COMMITTEE COMPOSITION

Handloom and Khadi Sectional Committee, TXD 08

<i>Organization</i>	<i>Representative(s)</i>
Weavers Service Centre, Delhi	SHRI VISHESH NAUTIYAL ( <b>Chairperson</b> ) SHRI VIKAS KUMAR ( <i>Alternate</i> )
Central Pollution Control Board, New Delhi	SHRI P. K. MISHRA SHRI RISHABH SRIVASTAV ( <i>Alternate</i> )
Center of Excellence for Khadi (COEK)-NIFT, New Delhi	REPRESENTATIVE
CRPF, New Delhi	SHRI D. P. UPADHYAY SHRI SANJEEV KUMAR SINGH ( <i>Alternate</i> )
Department of Handlooms & Textiles, Chennai	SHRI THIRU R. RAGHUNATH SHRI THIRU K. MUNUSAMY ( <i>Alternate</i> )
Fabindia, New Delhi	REPRESENTATIVE
Flag Foundation of India, New Delhi	SHRI ASHIM KOHLI
Gandhigram Rural Institute, Dindigul	DR B. SENTHIL KUMAR
Haryana Khadi Gramodyog Sangh, Karnal	SHRI PAWAN GARG SHRI R. S. YADAV ( <i>Alternate</i> )
ICAR – Central Institute for Research on Cotton Technology, Mumbai (CIRCOT)	DR SUJATA SAXENA DR A. S. M. RAJA ( <i>Alternate</i> )
Indian Institute of Handloom Technology, Jodhpur	DR J. SIVAGNANAM
Indian Institute of Handloom Technology, Salem	DR P. THENNARASU
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Indian Institute of Technology, Delhi	DR BIPIN KUMAR DR WAZED ALI ( <i>Alternate</i> )
Indo Tibetan Border Police, New Delhi	SHRI UTTAM KUMAR SHRI ANAND KUMAR ( <i>Alternate</i> )
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Karnatka Khadi Gramodyog Samyuktha Sangha, Hubli	SHRI K. V. PATTAR SHRI SHIVANANDA S. MATHAPATI ( <i>Alternate</i> )
Khadi Dyers & Printers, Mumbai	SHRI D. N. BHATT SHRI V. D. JOSHI ( <i>Alternate</i> )
Khadi Gramodyog Mandal, Rampur	SHRI RAKESH CHAUDHARY SHRI PRINCE CHAUDHARY ( <i>Alternate</i> )

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<i>Organization</i>	<i>Representative(s)</i>
Khadi and Village Industries Commission, Mumbai	SHRI VIJAYSRIDHAR DR SENTIL KUMAR C. B. ( <i>Alternate</i> )
Kshetriya Khadi Gramodyog Samiti, Dausa	SHRI R. K. SINGH
Madhya Bharat Khadi Sangh, Gwalior	SHRIMATI NEELU MEKLE SHRI HARISH MEKLE ( <i>Alternate</i> )
Mahatma Gandhi Institute for Rural Industrialization, Wardha	SHRI MAHESH KUMAR DR TAPAN RANJAN KAR ( <i>Alternate</i> )
Metpalli Khadi Gramodyog Pratisthan, Metpalli	SHRI G. MADHAV
Ministries of Defence (DGQA), New Delhi	SHRI ARVIND COMPATHANE SHRI N. SENTHIL KUMAR ( <i>Alternate</i> )
Ministries of Health, New Delhi	REPRESENTATIVE
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Northern Railways, New Delhi	SHRI SANJEEV KUMAR JAIN SHRI RAJESH KUMAR ( <i>Alternate</i> )
Northern India Textile Research Association, Ghaziabad	DR M. S. PARMAR SHRI SANJEEV SHUKLA ( <i>Alternate</i> )
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The Tamil Nadu Handloom Weavers' Cooperative Society Ltd, Chennai	SHRI T. N. VENKATESH SHRI K. KATHIRESAN ( <i>Alternate</i> )
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